

153527

Monday, November 21, 2016 9:24:06 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

4

4

Run Start *NR1*

Date: _____

Date: _____

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

4

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____



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Work Order ID 153527

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Page 3

Item ID: D4918-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Fwd
Start Date: 11/14/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/21/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 134858</i> Memo START TIME: <i>1:10</i> <i>3:00</i> FINISH TIME: <i>1:40</i> OVEN TEMPERATURE:	0.00 0.03				<i>4</i>	<i>0</i>	<i>16-11-30</i>	<i>33 34 35</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>cmf</i>	<i>16-12-01</i>		<i>DAS 11 9-88</i>
164 *164* HandFinish Hand Finishing	Coat entire top concave surface with Rockguard as per dwg and QSI A/R Rockguard: <i>136205</i> Memo	0.00 0.07				<i>4</i>		<i>16-12-01</i>	<i>16-12-01</i>

DQA: _____ Date: _____



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
166 *166* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>4/</u>			DAS 38 9-89 NOV 02 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-002</u> Memo LOCATION : FP001	0.00 0.01				<u>4</u>	<u>4</u>	<u>11/12/16</u>	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							DAS 21 9-89 DEC 02 2016

DAS
21
9-89

DEC 02 2016

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Picklist Print

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Page 1

Work Order ID: 153527

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Parent Item: D4918-1

D4918-1

Parent Item Name: Wearplate Fwd

Start Date: 11/14/2016

Required Date: 11/21/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.12.09 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased				100	sf	125.3210	0.242	1.018947			

M304S20GA

304/316 .040 Sheet

11/21/21

Location

Loc Qty

Loc Code

MAT020

124.5

m134495

0.2

m134982

0.1

m135327

71.7

m135689

52.5

MAT20

0.821

m133901

0.821

1.3

DQA: _____ Date: _____

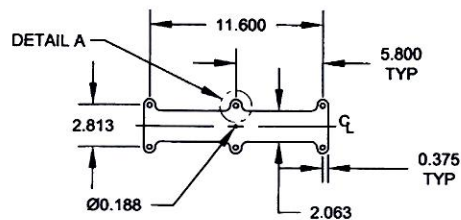


WORK ORDER NON-CONFORMANCE / UPDATE

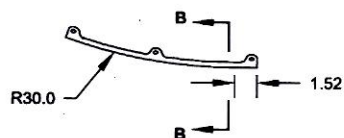
QA Closed: _____ Date: _____

Work Order update only ☐

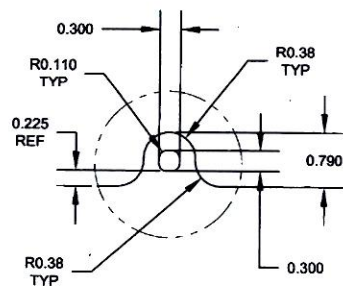
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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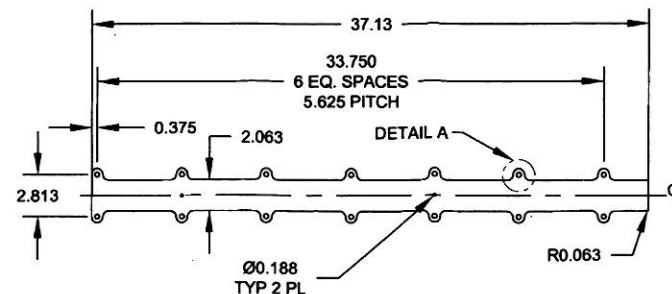
D4918-1F FLAT PATTERN



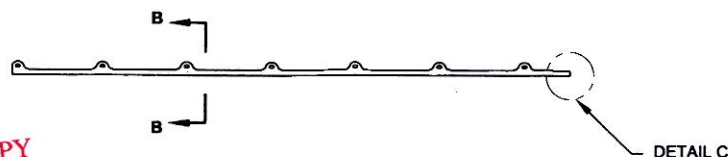
D4918-1 BENDING DETAIL
(MAKE FROM D4918-1F)



DETAIL A
(SCALE 4X)

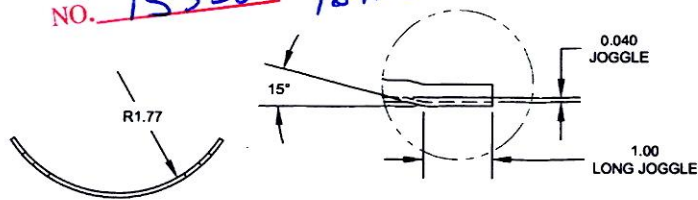


D4918-3F FLAT PATTERN

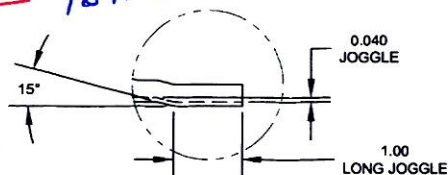


D4918-3 BENDING DETAIL
(MAKE FROM D4918-3F)

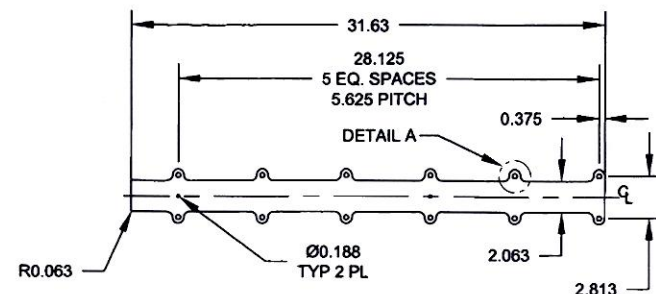
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153527 *ML5*
10-11-21



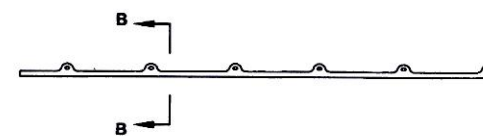
SECTION B-B
(SCALE 4X)



DETAIL C
(SCALE 4X)



D4918-5F FLAT PATTERN



D4918-5 BENDING DETAIL
(MAKE FROM D4918-5F)

RELEASED
2013-12-10

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D4918-1 - 0.47 lbs, D4918-3 - 0.95 lbs, D4918-5 - 0.77 lbs,
 - 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

REV.	NEW ISSUE	DESCRIPTION	DW	13.08.30
DESIGN	DW		BY	DATE
DRAWN	DW			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	13.08.30			

DART AEROSPACE USA, INC KENT, WA	
DRAWING NO. D4918	REV. A SHEET 1 OF 3
TITLE WEARPLATE	SCALE NTS

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